

Date: Monday, 02/03/2009 11:25:47 AM
 User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : DOOR DOUBLER

Job Number : 46196

Estimate Number : 12681

P.O. Number :

Part Number : D3594043

This Issue : 02/03/2009 S.O. No. :

Drawing Number : D3594 REV B

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SMALL / MED FAB

Drawing Revision : B

Previous Run : 45194

Material :
Due Date : 16/03/2009

Qty: 8 Um: Each

Written By : JUD 09-03-02Checked & Approved By : JUD 09-03-02

Comment : Est Rev : A New Issue 07-01-22 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 4.2840 sf(s)

6061-T6 .080 Sheet

Batch: 111003

ml 09 03 06 (8)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

ml 09 03 06 (8)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 03 06

(8)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

508/03/06 (48 -3)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

4/30/09/03/09 (8)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 46196

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/09

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CMO/PK

09/03/09

(X8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 09/03/09

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Anchor nuts

BATCH:

M107938

(1x) SB

M111310

09/04/01

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

BATCH:

M15541

M15541

09/04/01

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

09/04/01 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/01 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

248B

9/4/12

SB

Job Number: 46196

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

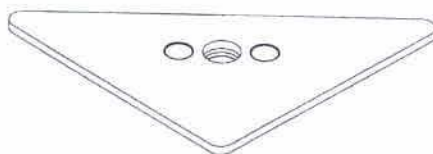


MF 09-04-02

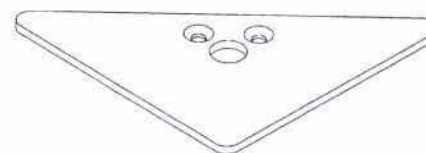
09.03.26

X	First Article		Prototype
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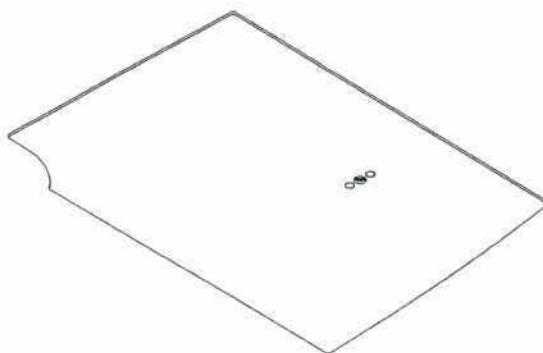
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-043	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	



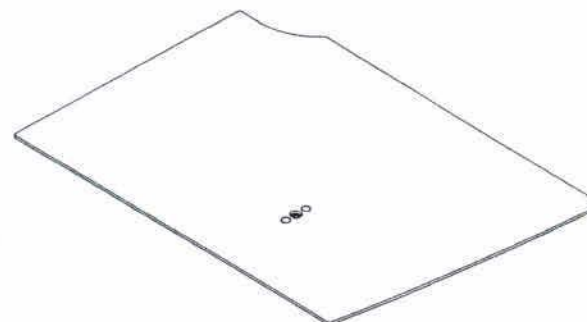
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



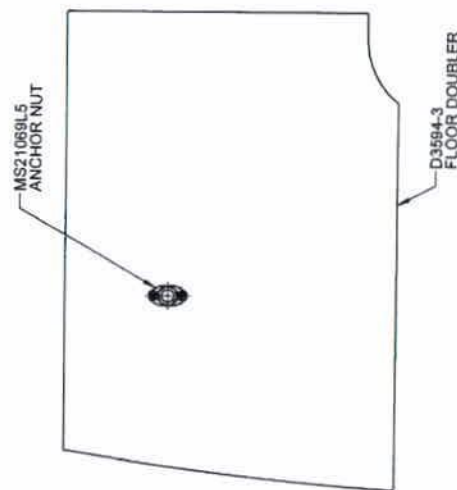
D3594-044 FLOOR DOUBLER ASSEMBLY

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B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD-5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 TITLE DOUBLER DATE 08.05.14 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. THESE SUPPLIES OR THE EXPENSE OF THIS DRAWING ARE NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV.	
		SHEET 1 OF	
		SCAL	
		NT:	

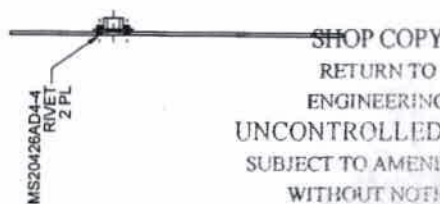
QTY.	QTY.	PART NUMBER	DESCRIPTION
-043	-044		
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



MS21069L5
ANCHOR NUT

D3594-3
FLOOR DOUBLER

D3594-043 FLOOR DOUBLER ASSEMBLY



MS21069L5
ANCHOR NUT

D3594-4
FLOOR DOUBLER

D3594-044 FLOOR DOUBLER ASSEMBLY

MS20426AD4-4
RIVET
2 PL

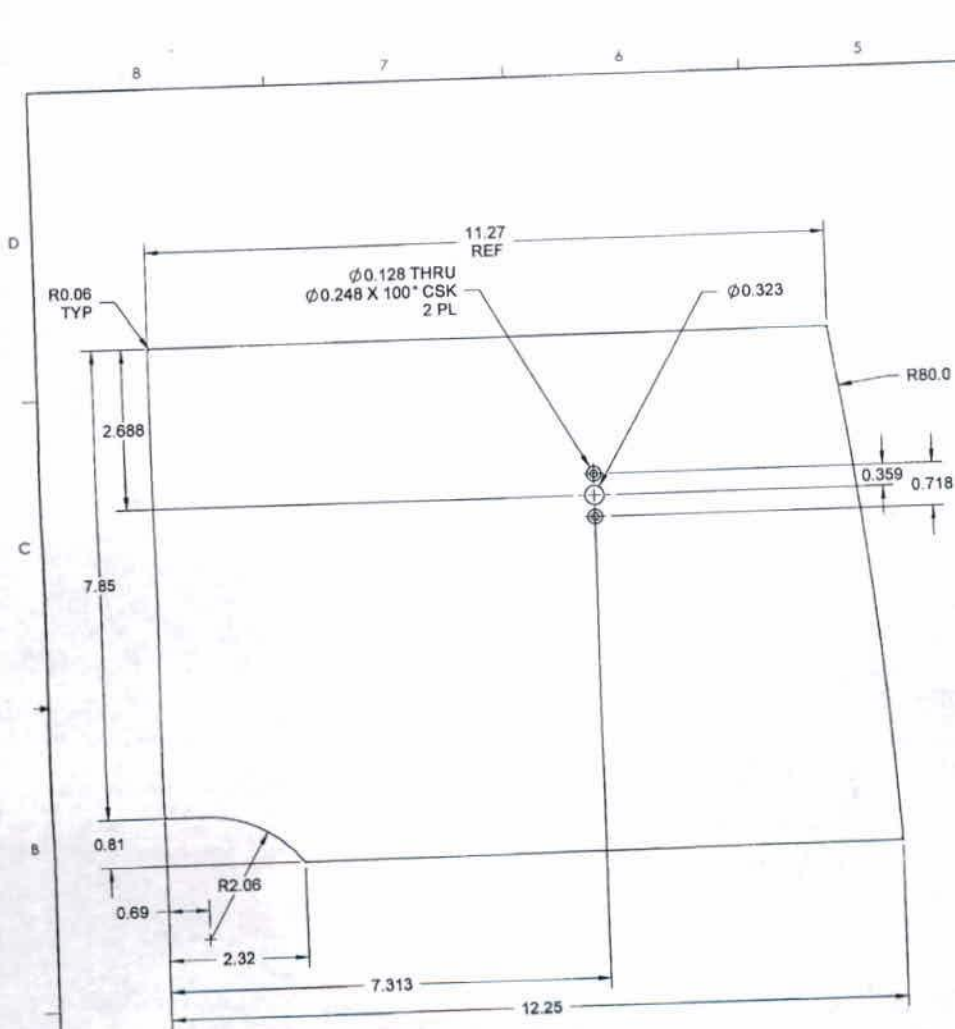
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08-05-14

- NOTES:
- 1) MATERIAL: -3 & -4 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 - 7) WEIGHT -043 & -044: 0.80 lbs

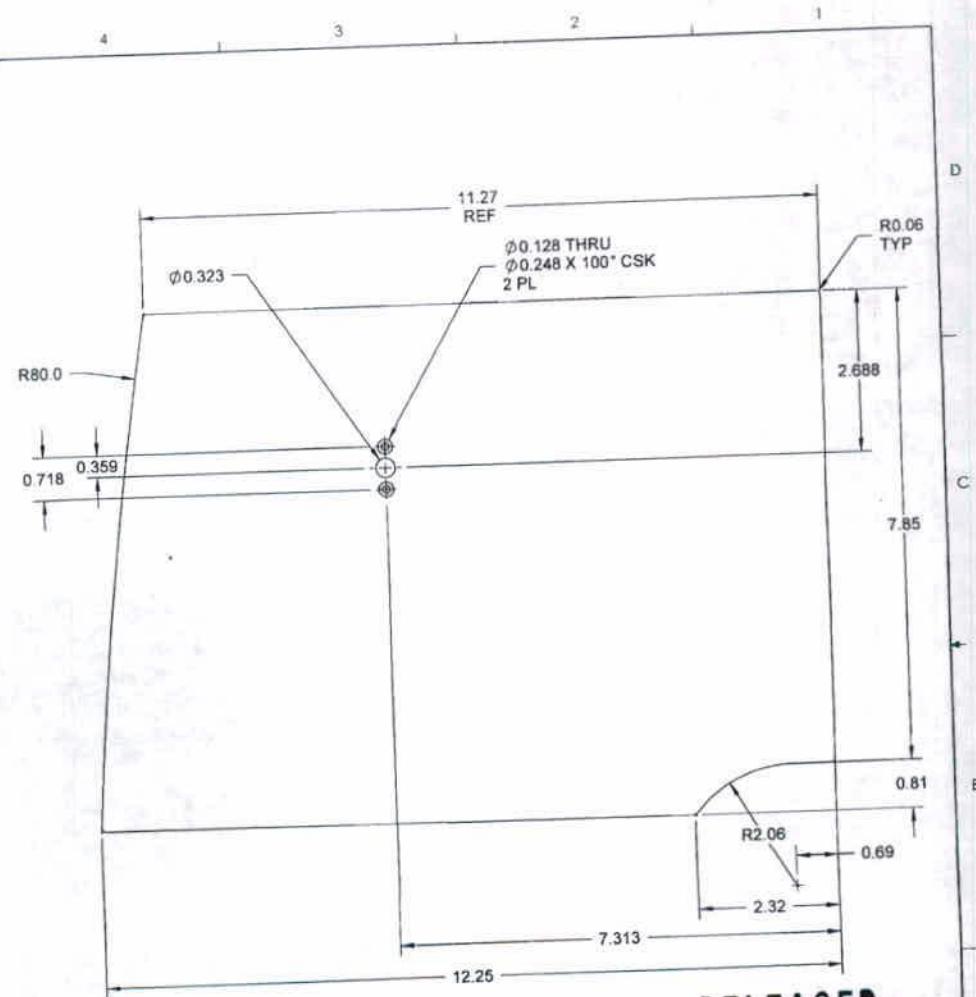
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MFG. APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14		

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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

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08.05.14

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	SCALE NTS
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